

# Work Order ID 115417

March-31-14 10:21:44 AM

**\*115417\***

Page 1

Item ID: D4542-5

D 4242-5  
B 115417

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Inner

Start Date: 3/31/14 Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 4/01/14 Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4542

E

100

0.00

**\*100\***

Waterjet

FLOW CNC Waterjet

Memo

1- Cut as per dwg  
Prog rev: E  
Dwg rev: E

2- Deburr

0.00

12 0 Jm14-03-31  
mm

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Quality Control

Memo

0.00

12 0 Jm14-03-31  
mm

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Item ID: D4542-5

Revision ID:

Item Name: Retainer, Inner

Start Date: 3/31/14

Start Qty: 12.00

**\*12\***

Required Date: 4/01/14

Req'd Qty: 12.00

**\*12\***

Reference:

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

QC: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

Quality Control

0.00

125

Chemical Conversion Coat per QSI005 4.1

0.00

**\*125\***

HandFinish

Memo

Hand Finishing

0.00

127

QC7-Inspect Chemical Conversion Coat

0.00

**\*127\***

QC

Memo

Quality Control

0.00

# Work Order ID 115417

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**\*115417\***

Page 3

Item ID: D4542-5  
Revision ID:  
Item Name: Retainer, Inner  
Start Date: 3/31/14 Start Qty: 12.00 **\*12\***  
Required Date: 4/01/14 Req'd Qty: 12.00 **\*12\***  
Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: ST532

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

12x 14-4-1

DAS  
26  
9-89

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

MLJ 14-04-01

14-04-01

# Picklist Print

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Page 1

Work Order ID: 115417

\*115417\*

Parent Item: D4542-5

\*D4542-5\*

Parent Item Name: Retainer, Inner

Start Date: 3/31/14

Required Date: 4/01/14

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B  
12.02.24 as per dwg revA DD verf:EC IPP REV:C 12.05.08 as  
per dwg revB DD verf:EC IPP REV:D 13.04.23 as per dwg revD  
DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.032

Purchased

No

100

sf

317.3832

0.208

3

\*M6061T6S 032\*

\*\*

14-03-31  
mm

6061-T6 Sheet 0.032"

Location

Loc Qty

Loc Code

MAT021

317.38317

123483

8.57

m125822

17

m127272

119.43317

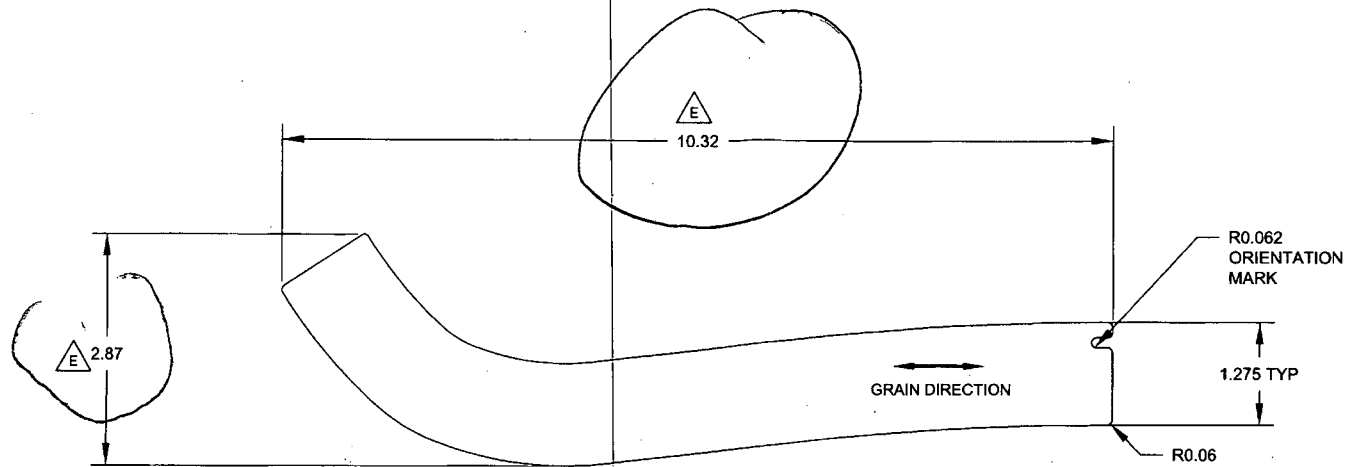
m128054

172.38

128054

128





**D4542-5 RETAINER, INNER**  
(TOP CORNER)

who  
115417

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs
- 8) PROFILE PER DRAWING FILE "D4542-5-REVE.DXF"

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AUS		
CHECKED	JS	DRAWING NO.	REV. E
MFG. APPR.	JS	D4542	SHEET 4 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	RETAINER, INNER	NTS
DATE	14.03.17	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	







